

Work Order ID 52150

Thursday, September 17, 2009 8:09:58 AM

Page 1

Item ID: D209-669-014

Accept

Revision ID: B

Item Name: Skidtube RH

Start Date: 9/18/2009 Start Qty: 1.00

Required Date: 10/9/2009 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D209-669-014

Rev B

DSI 9450

Rev A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D209-669-014 CHG003

5 09/10/09

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

9/30/09/30 ①

Work Order ID 52150

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Page 2

Item ID: D209-669-014

Accept

Revision ID: B

Item Name: Skidtube RH

Start Date: 9/18/2009 Start Qty: 1.00

Required Date: 10/9/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

⇒ 505/10/03

0.00

Memo

Ⓚ

/

130



Packaging

Packaging

Packaging

0.00

REUC

0.00

Memo

Identify and pack for shipping as per PPPD209-669-014

Location: _____

9/10/09 SV

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

09/10/09 AG

52114

PL
09-10-2

Picklist Print

Thursday, September 17, 2009 8:09:57 AM

Page 1

Work Order ID: 52150

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/18/2009

Required Date: 10/9/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

S D209-669-043RevB
Replacement Skidtube

Manufactured No

110

Each

3.0000

1.0000

52114 9/10/2009

Warehouse
Location

Loc Qty

Loc Code

Premier

Mezz

3

22797

1

39205

1

39206

1

S D2917-2RevB

Manufactured No

110

Each

3.0000

2.0000

52128 9/10/2009

Saddle RH

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

FG

3

51328

3

S D2918-2RevB

Manufactured No

110

Each

3.0000

2.0000

8/509/09/30

Saddle RH

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

3

43138

1

51330

2

B52132

(2x)

Picklist Print

Page 2

Thursday, September 17, 2009 8:09:57 AM

Work Order ID: 52150



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-51A Purchased No

110

Each

354.0000

8.0000



Bolt

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

354

110328

2

111635

102

112314

100

112489

100

112641

50

Ep 09/09/30

D2570RevB

Manufactured No

110

Each

139.0000

24.0000



Bushing

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

15

47246

15

Main Warehouse

ST36

124

50356

124

351519

(24K)

Ep 09/09/30

Thursday, September 17, 2009 8:09:57 AM

Shop Packet Print

Page 2

Picklist Print

Thursday, September 17, 2009 8:09:57 AM

Work Order ID: 52150



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L4		Purchased	No			110	Each	8,148.000	24.0000			
Nut												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	8148	
107499	5	
108145	4	
110450	1	
110507	184	
111827	5996	
112314	1893	
15924	0	
7690	24	
8182	41	

EP 09/09/30

24

AN5-36A		Purchased	No			110	Each	555.0000	4.0000			
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	555	
109545	11	
110467	7	
110731	4	
112243	20	
112314	463	
112385	50	

EP 09/09/30

4

Picklist Print

Thursday, September 17, 2009 8:09:57 AM

Work Order ID: 52150



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH


Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516  Washer		Purchased	No			110	Each	1,097.000	8.0000			

EP 09/09/30
M112794 (8)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1097	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	43	
112082	247	
112314	500	

MS21042L5



Nut

Purchased

No

110

Each

1,279.000

4.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1279	
110382	10	
111636	269	
112314	1000	

EP 09/09/30
4

Picklist Print

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Thursday, September 17, 2009 8:09:57 AM

Work Order ID: 52150



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-7A

Purchased

No

110

Each

201.0000

16.0000



Bolt



Ep 09/09/30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

201

111668

1

112314

50

112385

50

112641

100

16

Picklist Print

Page 7

Thursday, September 17, 2009 8:09:57 AM

Work Order ID: 52150

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/18/2009

Required Date: 10/9/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2930RevB Spacer		Manufactured	No			110	Each	11.0000	2.0000			
---------------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
43378

11
11

9/30/09

D3405-041RevB Lug Assembly		Manufactured	No			110	Each	10.0000	1.0000			
-------------------------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
51254

10
10

B51673

2
9/30/09

AN4C47A Bolt		Purchased	No			110	Each	222.0000	4.0000			
-----------------	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
110847
112431
112489
112641

222
4
18
100
100

4
9/30/09

Thursday, September 17, 2009 8:09:58 AM

Shop Packet Print

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Picklist Print

Thursday, September 17, 2009 8:09:58 AM

Work Order ID: 52150



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-4 Nut		Purchased	No			110	Each	1,397.000	5.0000			

Ep 09/09/30

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
OFFSHORE		
FG	40	
104603	40	
Main Warehouse		
ST	1357	
111819	35	
112243	22	
112314	1000	
112492	300	

5

D3405-043RevB

Manufactured

No

110

Each

12.0000

1.0000



Lug Assembly

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST	12	
46589	1	
46863	1	
51255	10	

Ep 09/09/30

351652

(12)

Picklist Print

Thursday, September 17, 2009 8:09:58 AM

Work Order ID: 52150



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3407-041RevE Manufactured No

110

Each

35.0000

1.0000



Tow Ring



Ep 09/09/30

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

3

35780

3

Main Warehouse

ST

1

48356

1

Main Warehouse

ST464

31

51659

31

1

D3456-1RevA Manufactured No

110

Each

232.0000

1.0000



Washer



Ep 09/09/30

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

7

25701

7

Main Warehouse

ST

225

46752

25

51653

200

1

Picklist Print

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Thursday, September 17, 2009 8:09:58 AM

Work Order ID: 52150



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3417-5RevE

Manufactured

No

110

Each

152.0000

2.0000



Washer

EP 09/09/30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

152

51649

152

2

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

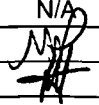

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32150

INSTRUCTIONS:

1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
- b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
- c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

A	NEW ISSUE	AJS	09.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

5.0 PARTS LIST

52150

ITEM	QTY -011	QTY -012	QTY -013	QTY -014	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		X					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			X				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				X			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
	1	1			X		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
			1	1		X	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)

IS:

50	4	4	1	1			D3405-041	LUG ASSEMBLY
51	8	8	4	4			AN4C47A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21043-4	NUT
54			1	1			D3405-043	LUG ASSEMBLY
60	1	1	1	1			D3407-041	TOW RING ASSEMBLY
61	1	1	1	1			D3456-1	WASHER
62	1	1	1	1			MS21043-4	NUT
63	2	2	2	2			D3417-5	WASHER

WAS:

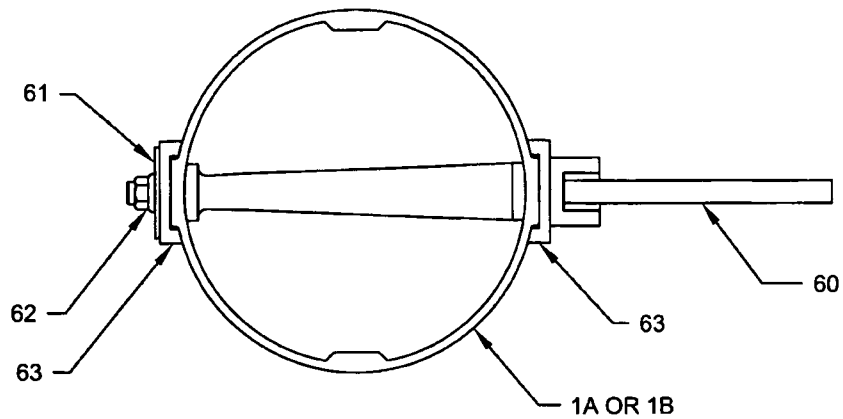
50	4	4	1	1			D2736-1	GHW LUG
51	8	8	4	4			AN4-46A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21042L4	NUT (OR MS21042-4)
54			1	1			D2736-3	GHW LUG
60	1	1	1	1			D2968-041	TOW RING
61	1	1	1	1			AN970-4	WASHER
62	1	1	1	1			MS21042L4	NUT (OR MS21042-4)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9450 SHEET 2 OF 3
APPROVED		TITLE SCALE
DE APPR.		SKIDTUBE INSTALLATIONS NTS
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE EXPRESS PERMISSION FROM DART AEROSPACE LTD.

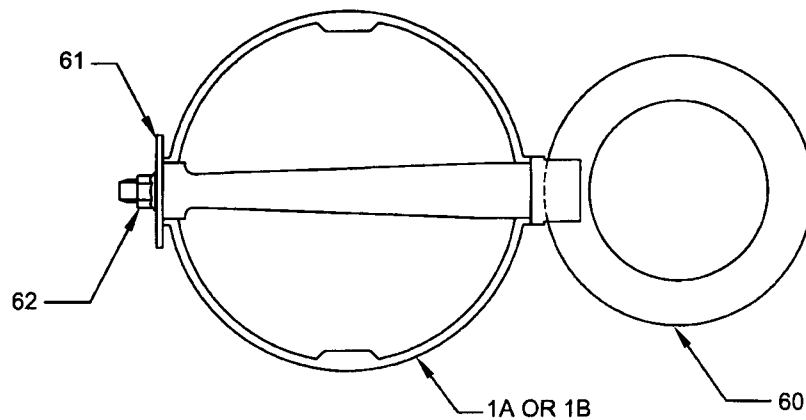
INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO SECTION F-F OF IIN-D209-669 REV. B.

52150

IS:



WAS:



NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

4.0 WEIGHT AND BALANCE

The following weight and balance information is for the replacement Dart parts. The weight and balance of the skidtubes that are being removed from the aircraft is the responsibility of the installer.

Installation	Weight	LONGITUDINAL	
		Arm	Moment
D209-669-011/-012	49.6 lb	170.4 in	8452 in lb
SKIDTUBE INSTALLATION	22.5 kg	4.33 m	97.4 m kg
D209-669-013/-014	43.8 lb	176.5 in	7731 in lb
SKIDTUBE INSTALLATION	19.9 kg	4.48 m	89.2 m kg

REFERENCE ONLY

5.0 PARTS LIST

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -041	Qty -043	Part Number	Description
	X						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		X					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			X				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				X			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
	1	1			X		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
			1	1		X	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)
1A					1		D2906-041	SKIDTUBE ASSEMBLY
1B						1	D2906-043	SKIDTUBE ASSEMBLY
2	1		2				D2917-1	OUTER SADDLE (FWD, LH)
3		1		2			D2917-2	OUTER SADDLE (FWD, RH)
4	1		2				D2918-1	INNER SADDLE (FWD, LH)
5		1		2			D2918-2	INNER SADDLE (FWD, RH)
6	1						D2919-1	OUTER SADDLE (AFT, LH)
7		1					D2919-2	OUTER SADDLE (AFT, RH)
8	1						D2920-1	INNER SADDLE (AFT, LH)
9		1					D2920-2	INNER SADDLE (AFT, RH)
10	8	8	8	8			AN4-51A	BOLT
11	16	16	16	16			D2570	BUSHINGS
12	8	8	8	8			MS21042L4	NUT (OR MS21042-4)
13	2	2	4	4			AN5-36A	BOLT
14	2	2					AN5-41A	BOLT
15	8	8	8	8			AN960JD516	WASHER
16	4	4	4	4			MS21042L5	NUT (OR MS21042-5)
17	16	16	16	16			AN4-7A	BOLT
18	32	32	32	32			AN960JD416	WASHER
19	16	16	16	16			MS21042L4	NUT (OR MS21042-4)

CONTINUED ON NEXT PAGE

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Revision: **B**
Date: 07.08.23

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CONTINUED FROM PREVIOUS PAGE

20	2	2	2	2			D2929	SPACER
21	2	2	2	2			D2930	SPACER
*30A					1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
*30B					1	1	D3566-1	GASKET
*31A					1		D3564-15	WEARSHOE (REPLACES 18" D2577-5)
*31B					1		D3566-15	GASKET
*32A					1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
*32B					1	1	D3566-1	GASKET
*33A					1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
*33B					1	1	D3566-5	GASKET
*34					50	44	AN3C4A	BOLT (REPLACES AN3-4A)
*35					50	44	AN960C10L	WASHER (REPLACES AN960JD10L)
*36					50	44	AKS7-1032-130	INSERT (OR ALS7-1032-130, OR ALS4-1032-130, OR AKS4-1032-130)
*37					12	14	D2594-1	PLUG
*38					12	14	D2594-3	O-RING
*40					2	2	D2855	AFT CAP
*41					4	4	AN3-5A	BOLT
*42					4	4	AN960JD10L	WASHER
*43					4	4	AKS7-1032-225	INSERT (OR ALS7-1032-225, OR ALS4-1032-225, OR AKS4-1032-225)
50	4	4	1	1			D2736-1	GHW LUG
51	8	8	4	4			AN4-46A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21042L4	NUT (OR MS21042-4)
54			1	1			D2736-3	LUG ASSEMBLY
60	1	1	1	1			D2968-041	TOW RING
61	1	1	1	1			AN970-4	WASHER
62	1	1	1	1			MS21042L4	NUT (OR MS21042-4)

* DENOTES THAT PART IS INCLUDED WITH D2906-041/-043 SKIDTUBE ASSEMBLY

52150

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